

Work Order ID 73647

Friday, September 09, 2011 8:45:57 AM



Page 1

| | | | | | |
|--------------------------|-----------------|--|---------------|-------|--|
| Item ID: D3913-1 | Accept | | Setup | Start | |
| Revision ID: | | | | Stop | |
| Item Name: Rib | | | | | |
| Start Date: 9/9/2011 | Start Qty: 3.00 | | Cust Item ID: | | |
| Required Date: 9/15/2011 | Req'd Qty: 3.00 | | Customer: | | |
| Reference: | | | | | |

| | | | | | | | |
|------------|------------------------|-------------|------------------|-------------|-----|-------|--|
| Approvals: | Process Plan: <u>W</u> | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3913 | A |

| | | | | | | | | | |
|-----------|---|------|--|--|--|--|--|--|--|
| 100 | | 0.00 | | | | | | | |
| | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1- Cut tube as per dwg D3913 2- Drill hole as per dwg ***one side only*** 3- remove identification marks and deburr | | | | | | | | |

| | | | | | | | | | |
|-----------------|------------------------------------|------|--|--|--|--|--|--|--|
| 110 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|-----------|---|------|--|--|--|--|--|--|--|
| 120 | Identify as per dwg & Stock Location: <u>WA 6</u> | 0.00 | | | | | | | |
| | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

Pl 11-09-16

(X3)

8/10/116

(X3)

Pl 11-09-16

(X3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 73647

Friday, September 09, 2011 8:45:57 AM



Page 2

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 9/9/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/11
R11-09-14
(3)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Friday, September 09, 2011 8:45:53 AM

Page 1

Work Order ID: 73647

Parent Item: D3913-1

Parent Item Name: Rib



Start Date: 9/9/2011

Required Date: 9/15/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B
add drill one side only DD 10.04.12 verified by:EC IPP Rev:C 11.01.18
chg qc5 to 6 DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304TS0.750W.049

Purchased

No

100

f

286.1659

8

25.26316



304 SQ Tube .75x.75x.049W



Pl 11.09.16

Location

Loc Qty

Loc Code

MAT018

185.4106839

117775

98.2133

118472

87.1973839

MAT034

1.8507

117337

1.8507

WA

98.90454

118184

98.90454

M118880 -> 25.2631

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

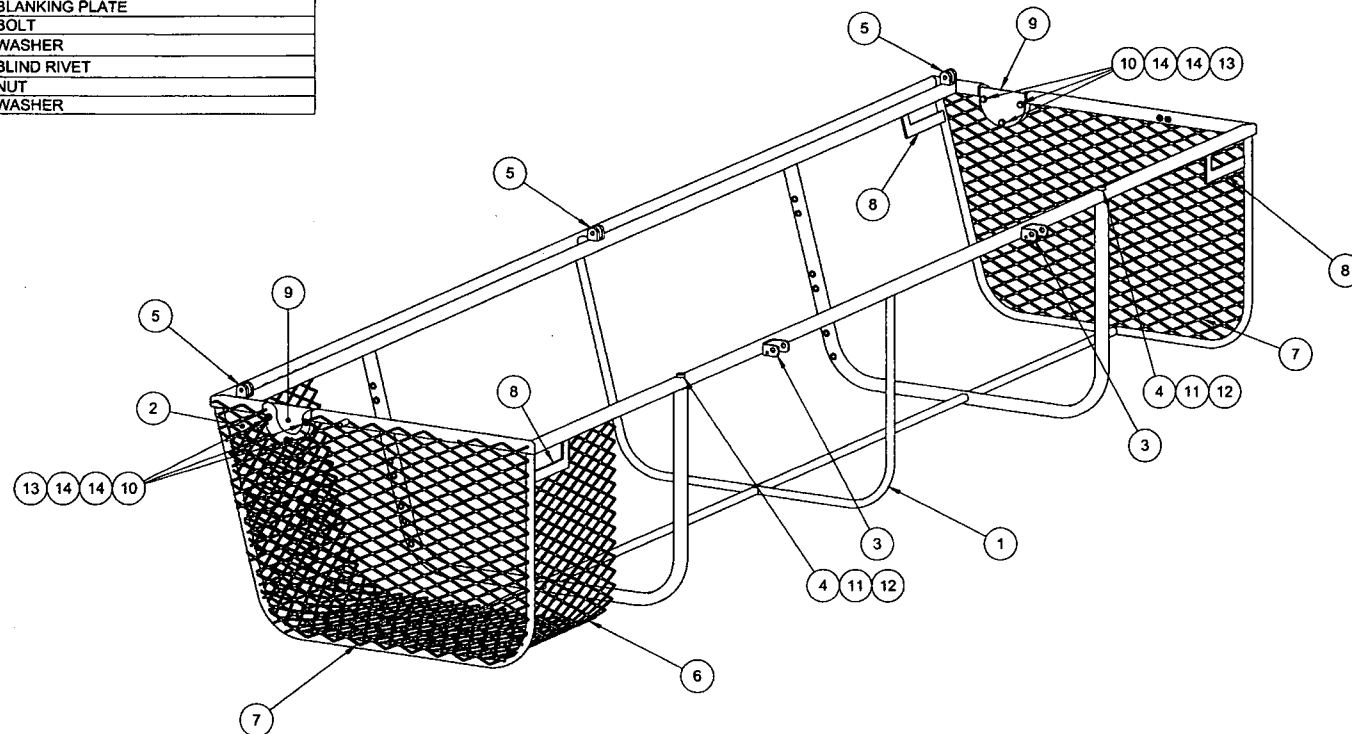
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------|
| | X | D3913-041 | LONG BASKET BASE ASSY (350) |
| 1 | 1 | D3913-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 3 | 2 | D2581 | MOUNTING BRACKET |
| 4 | 2 | D2931 | BUMPER |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-1 | MESH (350 BASKET LONG BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN980JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | BLIND RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

RELEASED
2010-03-22

| | | | |
|-------------|-------------|--|----------|
| A NEW ISSUE | | JPH | 10.03.16 |
| REV. | DESCRIPTION | | BY DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JFH | | |
| CHECKED | | DRAWING NO. D3913 | REV. A |
| MFG. APPR. | | SHEET 1 OF 6 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) NTS | |
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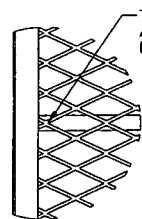
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

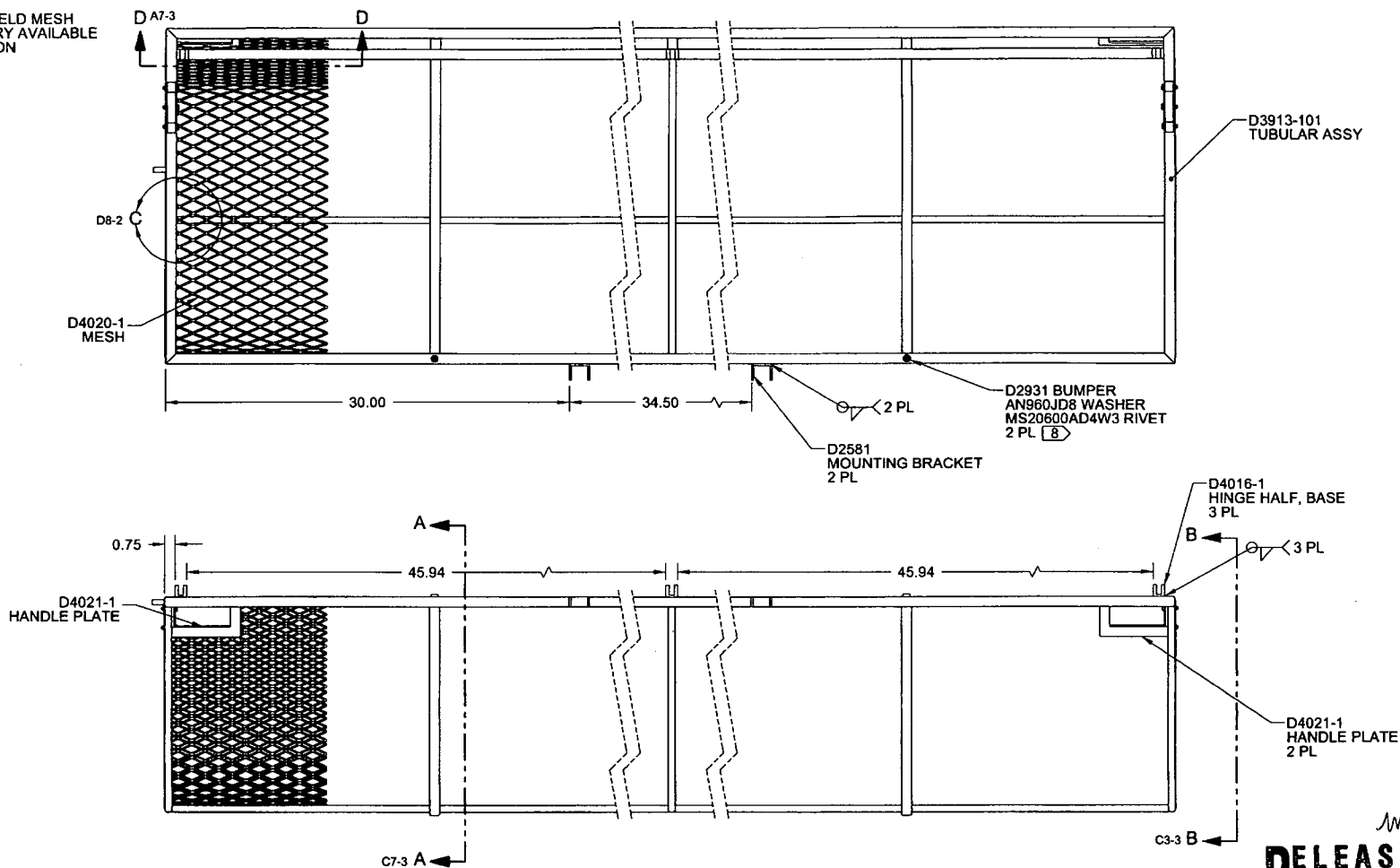
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| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



DETAIL C D7-2



D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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2010-05-27

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 2 OF 6 |
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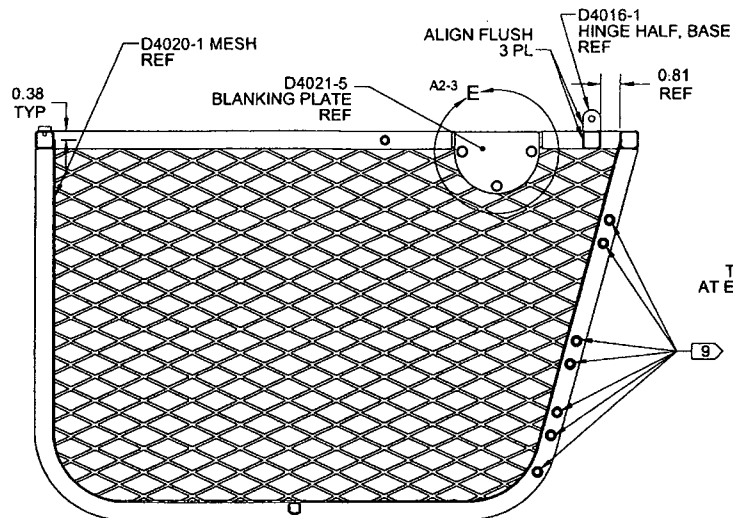
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

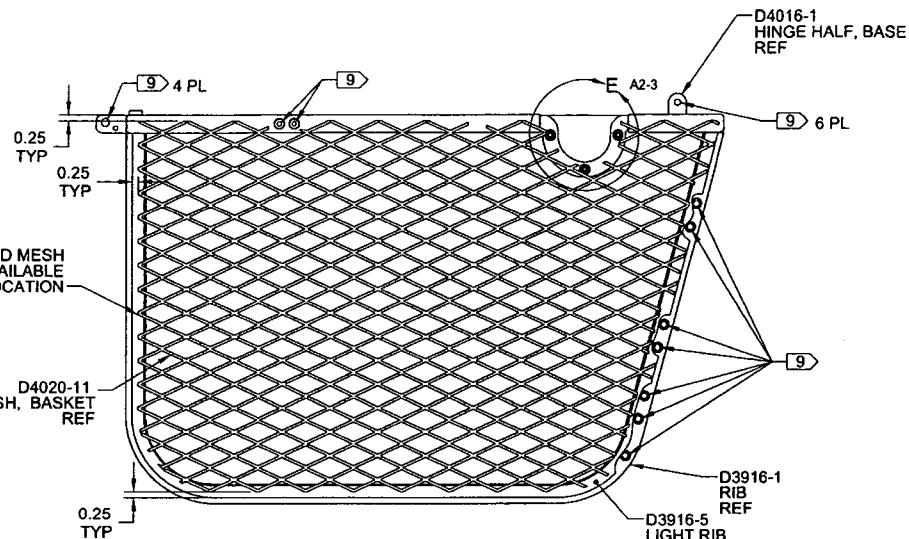
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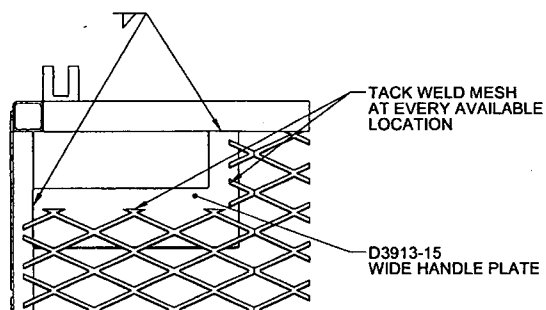
NOTE: Date & initial all entries



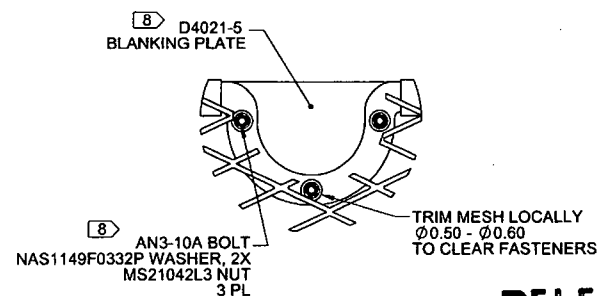
SECTION A-A A5-2



VIEW B-B A2-2



SECTION D-D D7-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

RELEASED
2010-03-22

| | | | |
|------------|---------------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JFH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JS | DRAWING NO. | REV. A |
| MFG. APPR. | JS | D3913 | SHEET 3 OF 6 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | LONG BASKET BASE ASSY (350) | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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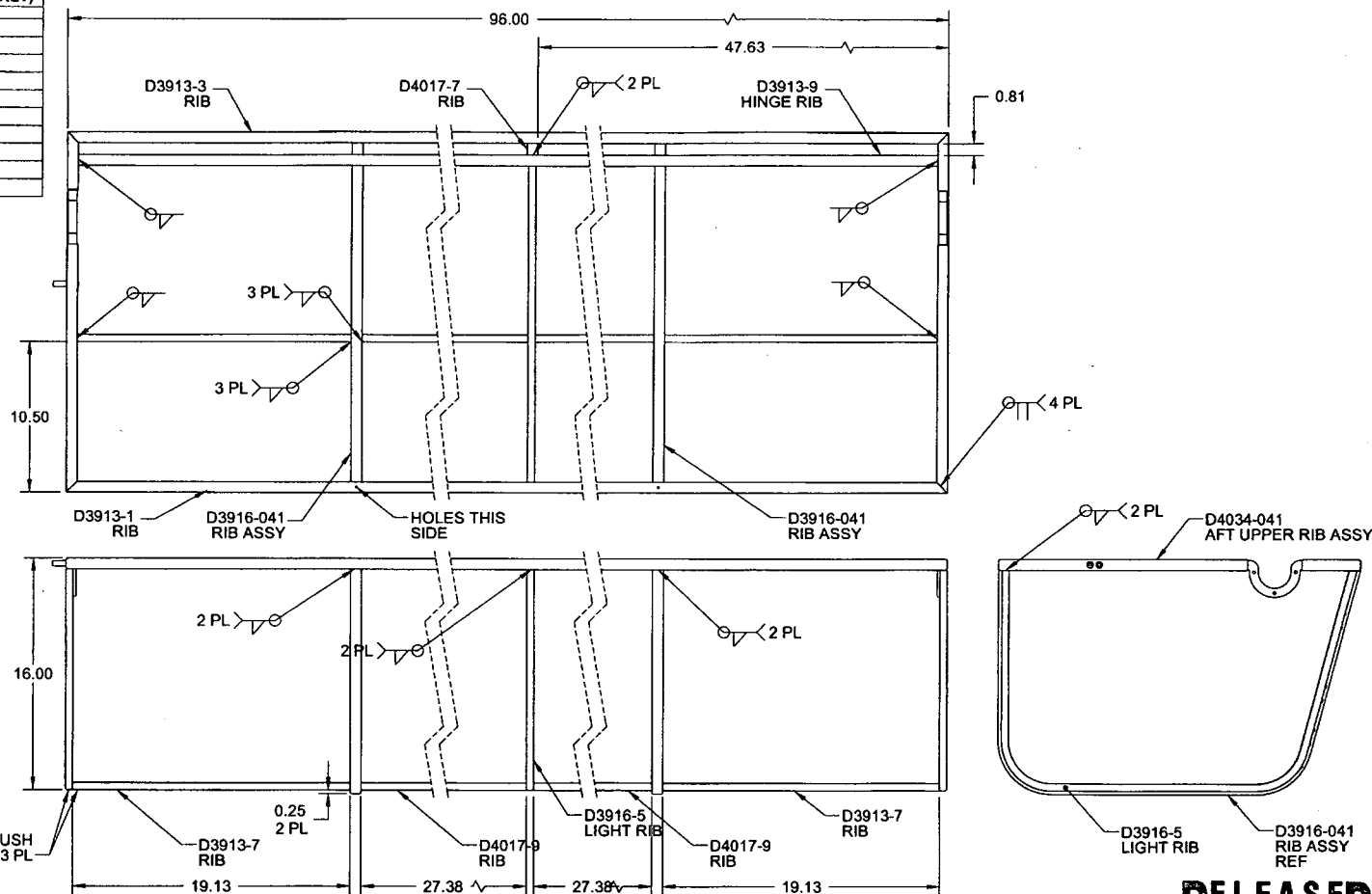
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------------------------|
| | X | D3913-101 | TUBULAR ASSY (350 LONG BASKET) |
| 1 | 1 | D3913-1 | RIB |
| 2 | 1 | D3913-3 | RIB |
| 3 | 2 | D3913-7 | RIB |
| 4 | 1 | D3913-9 | HINGE RIB |
| 5 | 3 | D3916-5 | LIGHT RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D4017-7 | RIB |
| 8 | 2 | D4017-9 | RIB |
| 9 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 10 | 1 | D4034-043 | FWD UPPER RIB ASSY |



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

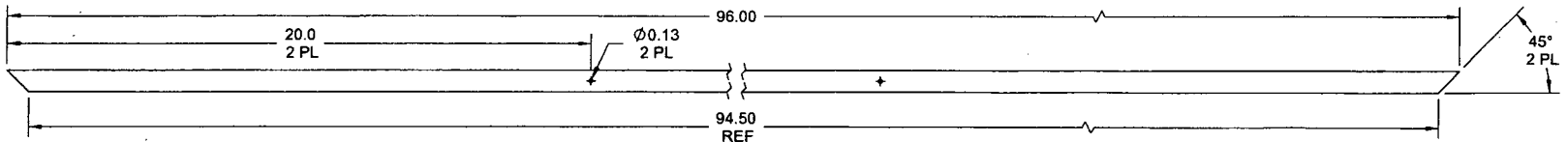
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
- 9) WELD PER DART QSI 004

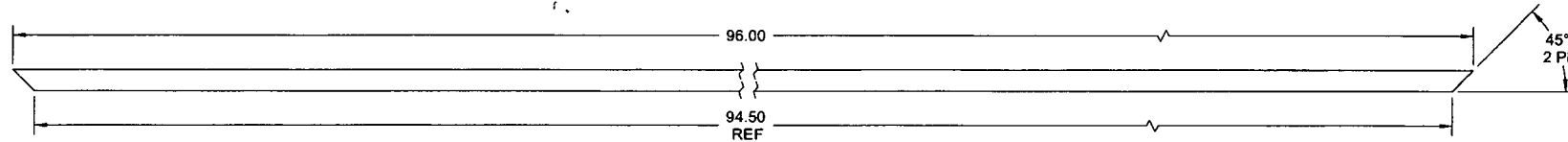
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| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JRH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 4 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) | NTS |
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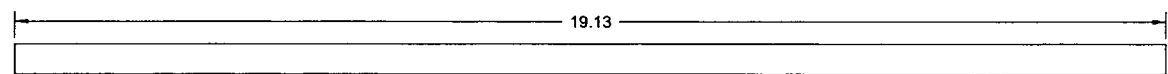
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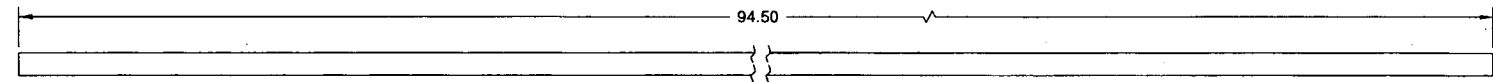
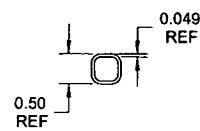
D3913-1 RIB



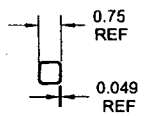
D3913-3 RIB



D3913-7 RIB



D3913-9 HINGE RIB



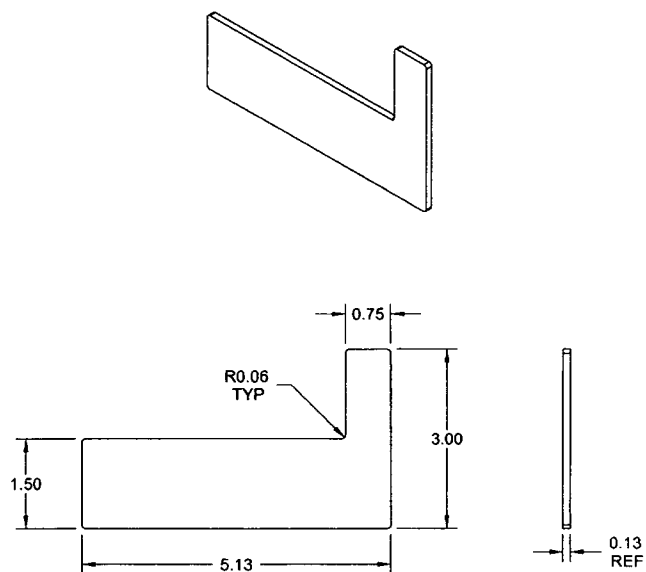
NOTES:

- 1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

73647

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2010-03-22

| | | | |
|------------|----------|---|--------|
| DESIGN | A/S | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | | DRAWING NO. D3913 | REV. A |
| MFG. APPR. | | SHEET 5 OF 6 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET BASE ASSY (350) NTS | |
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D3913-15 WIDE HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH : NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

73647

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JFH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3913 | SHEET 6 OF 6 |
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R 2010-03-22
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